

Work Order ID 71920

Wednesday, July 13, 2011 12:46:33 PM



Page 1

Item ID: D3281-2L08

Accept



Setup Start



Revision ID:

Item Name: Floor Protector, Fwd RH

Stop



Start Date: 7/13/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: *MW*

Date: 11-07-13

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3281

Rev F

100



HAND FINISHING THERMOFORMING

Thermoform

Memo

0.00

Thermoforming Machine

Cut Blanks

105



Dry Material

HandThermo

Memo

0.00

Hand Finishing Thermoforming

Dry Sheet as per QSI022 POLYCARBONATE

Temp: *740°F*Time IN: *4:30 pm 11/07/14*Time OUT: *7:00 am 11/07/15*
SL
11/07/15
SL
11/07/15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 71920

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Page 2

Item ID: D3281-2L08**Accept****Setup****Start****Revision ID:****Item Name:** Floor Protector, Fwd RH**Stop****Start Date:** 7/13/2011 **Start Qty:** 5.00**Cust Item ID:****Required Date:** 7/20/2011 **Req'd Qty:** 5.00**Customer:****Reference:****Approvals:** **Process Plan:****Date:****Tooling:****Date:****Run****Start****QC:****Date:****SPC (Y/N):****Date:****Stop****Sequence ID/
Work Center ID**

110

**Operation
Description**

THERMOFORMING MACHINE

**Set Up/
Run Hours**

0.00

Tool ID**Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

Thermoform

Thermoforming Machine

Memo

Thermoform as per Dwg. D3281 and Folio FTA 008

Dwg. Rev. FFolio Rev. O*x5**Dh,
11/07/15*

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

*x5**Dh,
11/07/15*

130



Thermoform

Thermoforming Machine

Memo

Trim to Finished Dimensions

0.00

0.00

*-x5-**Dh,
11/07/15*

W/O:		WORK ORDER CHANGES					
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Work Order ID 71920

Wednesday, July 13, 2011 12:46:33 PM



Page 3

Item ID: D3281-2L08

Accept



Setup Start



Revision ID:

Item Name: Floor Protector, Fwd RH

Stop



Start Date: 7/13/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 7/20/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

140



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Set Up/
Run Hours

0.00

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

x5

SL
11/07/18.

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

/ 11.07.2018 (5)

160



Packaging

Packaging

Packaging

Memo

0.00

0.00

11/7/21 (5) 59

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries

Work Order ID 71920

Wednesday, July 13, 2011 12:46:33 PM



Page 4

Item ID: D3281-2L08**Accept****Setup Start****Revision ID:****Stop****Item Name:** Floor Protector, Fwd RH**Start Date:** 7/13/2011 **Start Qty:** 5.00**Cust Item ID:****Required Date:** 7/20/2011 **Req'd Qty:** 5.00**Customer:****Reference:****Approvals:** Process Plan:**Date:****Tooling:****Date:****Run Start**

QC:

Date:**SPC (Y/N):****Date:****Stop****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

170



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/22/11
MF
11-09-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Wednesday, July 13, 2011 12:46:31 PM

Page 1

Work Order ID: 71920



Parent Item: D3281-2L08



Parent Item Name: Floor Protector, Fwd RH

Start Date: 7/13/2011

Required Date: 7/20/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev. A 10.02.24 New Issue LL
Add Step 105 Dry Material 10/04/21 DL

IPP REv. B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MLEXS.118-90318-08		Purchased	No			100	sf	2,044.205	5	26.31579			

Lexan Sheet

Location	Loc Qty	Loc Code
therm	2044.20578	
	2044.20578	

113127

26.31579 sq ft

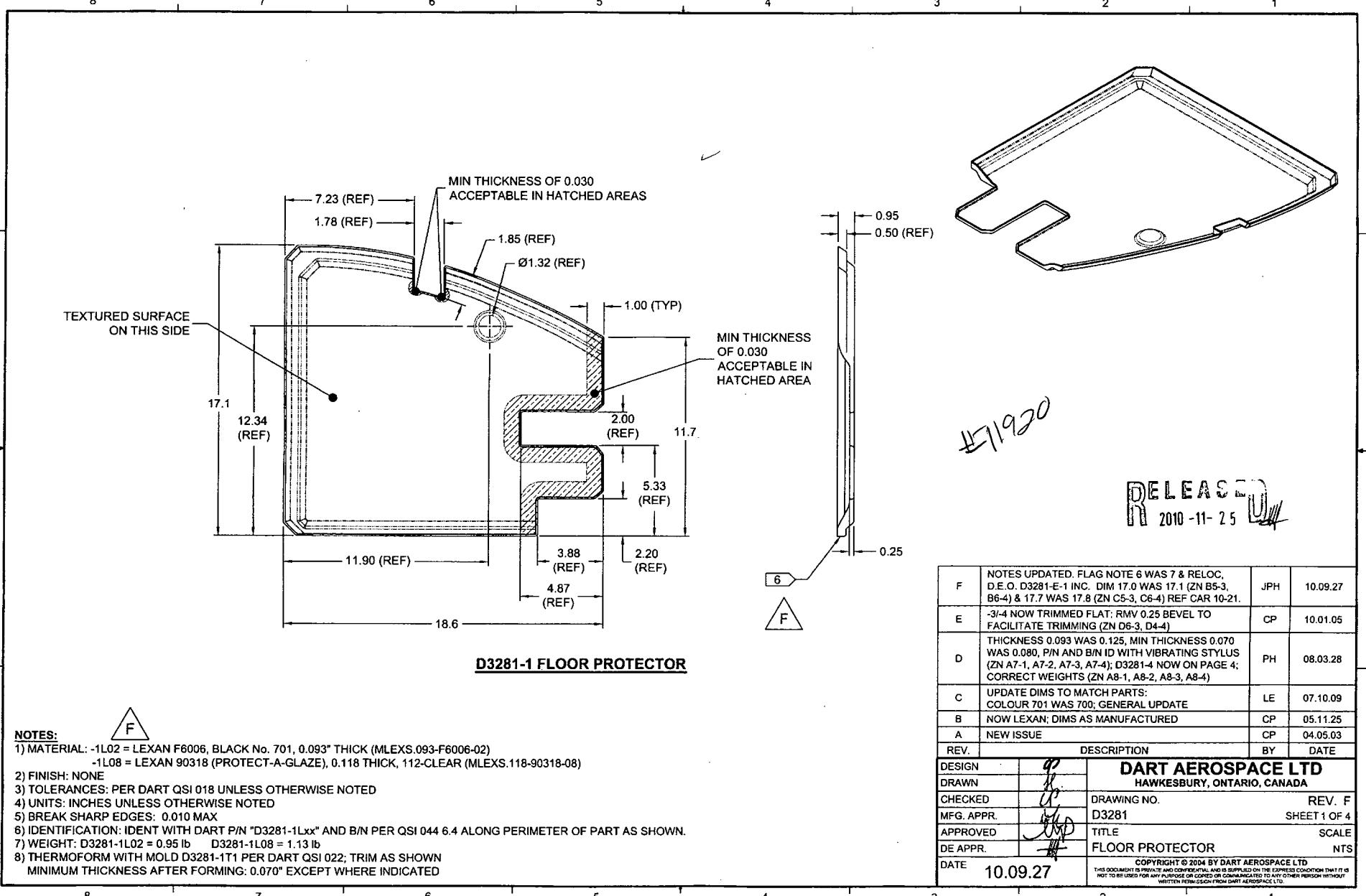
W.L.
11/07/18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries



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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

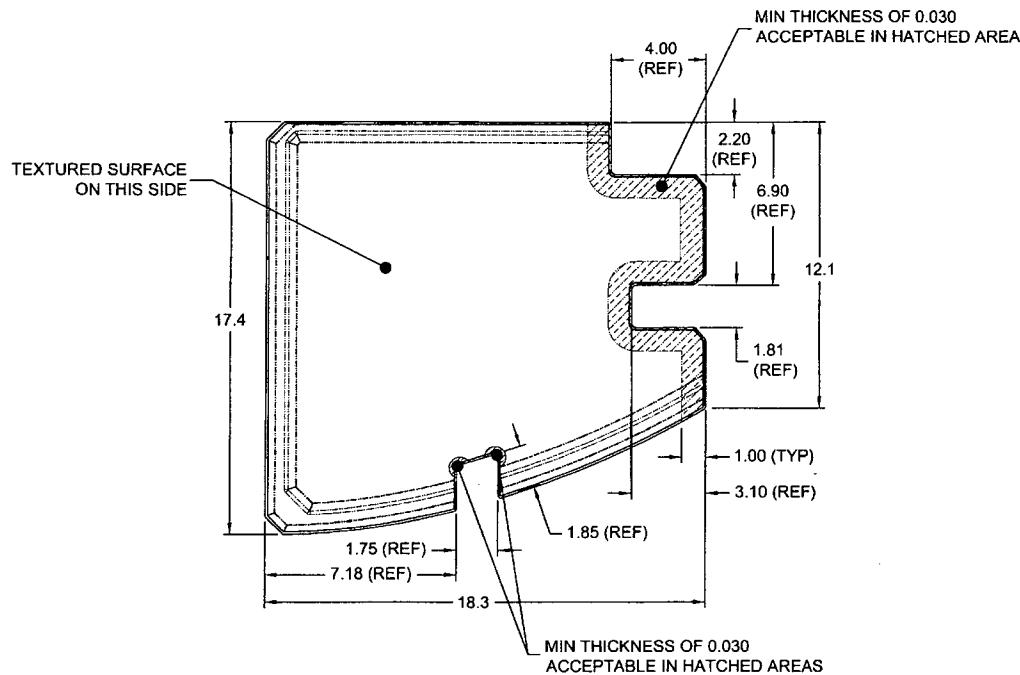
D

C

C

B

B

D3281-2 FLOOR PROTECTOR

NOTES:

- 1) MATERIAL: -2L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-2L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENT WITH DART P/N "D3281-2Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
- 7) WEIGHT: D3281-2L02 = 0.95 lb D3281-2L08 = 1.13 lb
- 8) THERMOFORM WITH MOLD D3281-2T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

8 7 6 5 4 3 2 1

DESIGN	<i>gp</i>	DART AEROSPACE LTD	
DRAWN	<i>gp</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>gp</i>	REV. F	
MFG. APPR.	<i>gp</i>	D3281 SHEET 2 OF 4	
APPROVED	<i>gp</i>	TITLE	
DE APPR.	<i>gp</i>	SCALE	
DATE	10.09.27	NTS	

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RELEASED
2010-11-25

A

A

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

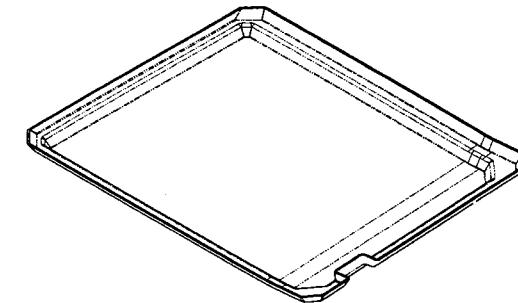
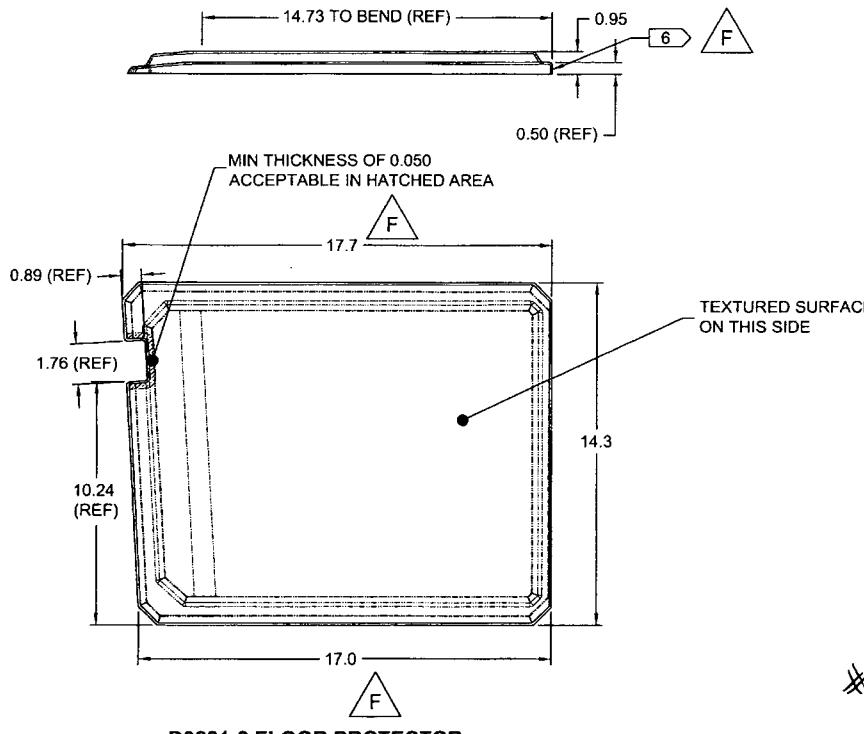
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D



#71920

RELEASED
2010-11-25

**NOTES:**

- 1) MATERIAL: -3L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
-3L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENT WITH DART P/N "D3281-3Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
- 7) WEIGHT: D3281-3L02 = 0.87 lb D3281-3L08 = 1.05 lb
- 8) THERMOFORM WITH MOLD D3281-3T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

8 7 6 5 4 3 2 1

DESIGN	OP	DART AEROSPACE LTD	
DRAWN	10	HAWKESBURY, ONTARIO, CANADA	
CHECKED	10	REV. F	
MFG. APPR.	10	DRAWING NO.	
APPROVED	10	D3281	SHEET 3 OF 4
DE APPR.	10	TITLE	SCALE
		FLOOR PROTECTOR	NTS
DATE	10.09.27	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

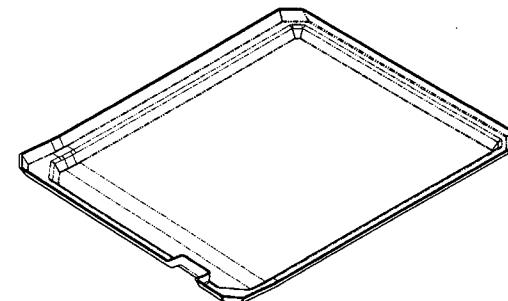
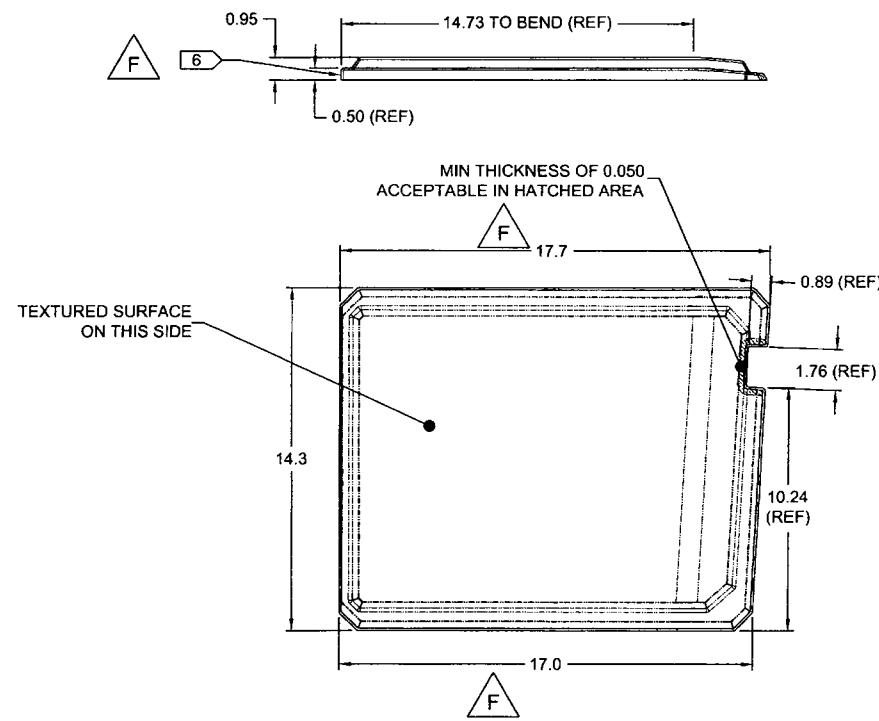
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

D

D



7192 C

DELEA L 2010-11-25 UN

D3281-4 FLOOR PROTECTOR**D3281-4 NOTES:**

- 1) MATERIAL: 4L02 = LEXAN F6006, BLACK No. 701, 0.093" THICK (MLEXS.093-F6006-02)
4L08 = LEXAN 90318 (PROTECT-A-GLAZE), 0.118 THICK, 112-CLEAR (MLEXS.118-90318-08)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.010 MAX
- 6) IDENTIFICATION: IDENTIFICATION: IDENT WITH DART P/N "D3281-4Lxx" AND B/N PER QSI 044 6.4 ALONG PERIMETER OF PART AS SHOWN.
- 7) WEIGHT: D3281-4L02 = 0.87 lb D3281-4L08 = 1.05 lb
- 8) THERMOFORM WITH MOLD D3281-4T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.070" EXCEPT WHERE INDICATED

8 7 6 5 4 3 2 1

DESIGN	<i>DP</i>	DART AEROSPACE LTD
DRAWN	<i>DR</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>DC</i>	REV. F
MFG. APPR.	<i>MF</i>	DRAWING NO. D3281 SHEET 4 OF 4
APPROVED	<i>AP</i>	TITLE FLOOR PROTECTOR NTS
DE APPR.	<i>DA</i>	DATE 10.09.27

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	71920
Description: Floor Protector, Fwd RH	Part Number:	D3281-2
Inspection Dwg: D3281 Rev: F		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than .01875" Go/No Go	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by:

W.L.

Date:

11/07/15

TRIMMING SECTION

Measured by:

Mr.

Date:

11/07/18

Audited by:

三

Date:

11/07/17

Preliminary Approval:

Date:

Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DL	
B	08.04.16	Dimensions updated per Dwg Rev D	KJ/DL	
C	08.07.23	Dwg Rev updated	KJ/DL	
D	08.09.12	Tolerance revised for 0.070 dimension	KJ/DL	
E	10.09.01	Dwg Rev updated	KJ	<i>[Signature]</i>
F	11.06.21	Dwg Rev updated	KJ	<i>[Signature]</i>

W/O:		WORK ORDER CHANGES					
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